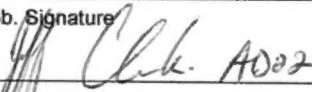


1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2014-03
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Long Cargo Basket	78410-01	1	78401-47	New
12. Remarks Modified with walkway on lid IAW DCL704; Black					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yyyy) 17 Feb 2014		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	


Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

WTS

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2014-03	
6. Item	7. Description Long Cargo Basket	8. Part Number 78410-01	9. Qty. 1	10. Serial/Batch No. 78401-47	11. Status/Work New	
12. Remarks Modified with walkway on lid and front end cutout on LH side IAW DCL704						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.						
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 06 Feb 2014		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

EUROCOPTERS / Imukoptere

CARGO BASKET ASSEMBLY - COMMON

2014-03

General

AS350 LONG BASKET

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket

76410, Revision 3 – Medium Basket (left or right)

→ 78410, Revision 2 – Long Basket

94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

70405, Revision 3? – Lid Walkway

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2014-03

AS350 Long

Date Open: 20 Jan 14

ADOC

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

ADOC

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ?? (0 FT LBS)

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation

ADD 6

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90" *AS LONG*
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig. ✓
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

- d. Record PO of hinge and rivets on attached material tracking list. ✓

4. Install Handle

AD06

a. Install handle brackets.

- Set 84267-01 handle bracket on provisions in hoops, 2 places.
- Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket. *ANTI SEIZE*
- Torque AN3 bolts to ?? *40 INCH LBS*

b. Install handle

- Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
- Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- At first end, remove bolt and repeat step iv.
- Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- Torque AN3 bolts to ??.

c. Check handle

- Operate handle to ensure handle does not bind and springs hold handle in.
- Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace

AD06

- Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- Ensure brace is seated on lip of bushings before tightening nuts.
- Torque AN3 bolts to ??
- Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

OK
AD01

6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: _____

Date Opened: _____

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Assembly

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			78410-01	Cargo Basket Assembly		
Step 1				<i>Lid Assembly</i>		
	. 1		78412-01	Basket Lid Assembly		
Step 1.a.	. . 4		49205-14	Bumper	Argus Industries Bumper	2014-03 11010
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		78427-01	Placard	0.063 Sheet, 6061-T6 Aluminum	78401-47
	. . 4		CR3213-4-02	Cherry Rivet		CR3213-4-02-13048
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	13066
	. . A/R		CR3213-4-02	Cherry Rivet		13048
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		
Step 2.a.	. 1		78411-01	Basket Body Assembly		2014-03
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	13042
	. . 8		NAS1149F0663P	Washer		130-4
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	90"	13061
	. 8		CR3523-5-02	Cherry Rivet		13049
	. A/R		CR3213-5-02	Cherry Rivet		13049
Step 4	. 1		84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	8426701
	. . 4		AN3-11A	Bolt		1408
	. . 8		NAS1149F0363P	Washer		13044
	. . 4		MS21044N3	Nut		13048

Work Order: _____

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Assembly

2 of 2

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		2013-54
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	12033
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	2013-33
	.. 2		AN3-12A	Bolt		13100 13084
	.. 4		NAS1149F0363P	Washer		13084
	.. 2		MS21044N3	Nut		13048
				<i>Lid Brace Installation</i>		
Step 5	. 1		36280-01	Brace Assembly	36280-02	with 2013-01
	. 1		AN3-15A	Bolt	13017	
	. 1		AN3-17A	Bolt	13017	
	. 2		AN970-3	Washer	13064	
	. 3		NAS1149F0363P	Washer	13084	
	. 2		MS21044N3	Nut	13048	
				<i>Inspection</i>		
Step 6					None	

CARGO BASKET HOOP FABRICATION - 76423

General

WO# 2014-03 20-Jan-2014

These instructions apply to cargo basket attachment hoop 76423-01 (medium AS350 basket) and 76423-07 (long AS350 basket). Refer to the following drawings, at the current revision, for dimensions and details:

76423, Revision 2 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly

Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order: 2014-03

Complete
(initial or SCA #)

Date Open: 20-JAN-2014

1. ½ Hoop Fabrication – ½" hoop AD06
 - a. Cut ½" x 0.035 material to 22.0", square ends.
 - b. Record material PO on attached material list.
 - c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
 - d. Remove writing on tubes with acetone and scotch bright.
 - e. On the hoop bending fixture, set the following stops:
 - i. Upper tube stop: ??"
 - ii. Lower bend stop: 12mm
 - f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
 - g. Slide shim all the way forward on bender to secure tube in die
 - h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
 - i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
 - j. Check for:
 - i. hoop height: 17 1/8" (Outside to outside)
 - ii. adjust upper stop for height if required
2. ½ Hoop Machining – ½" hoop – Handle Provisions (84262-01) AD06
 - a. Start with ½" half hoop from step 1.
 - b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
 - c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
 - i. locate 0.23" from edge (within tolerance specified on drawing).
 - d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
 - e. Tag in process hoop(s) and place into stock.

AD-06

3. ½ Hoop Fabrication – 1" hoop

- a. Cut 1" x 0.065 material to 28.0", one end square, one end @ 16 degrees.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
 - i. Upper tube stop: ??"
 - ii. Lower bend stop: ??
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for angle using hoop jig. Adjust stops if required.
- j. Check for:
 - i. hoop height from jig
 - ii. adjust upper stop for height if required
 - iii. length to allow 60 degree cut.
- k. Using hoop jig, mark for 60 degree cut on bottom end. Cut to length.
- l. De-burr cut end using a sanding disc on a die-grinder or disc sander.

4. ½ Hoop Machining – 1" hoop

AD-06

- a. Start with 1" ½ hoop as stock.
- b. Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.893" and set X 0. Shift Y -0.5". Set stop against end of tube.
- c. Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Set tube in vise with 60 degree end on right.
- f. Using ½" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
- g. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- h. Tag in process hoop(s) and place into stock.

5. Joint Preparation

AD-06

- a. Set 1" hoop in hoop jig. Insert ½" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto ½" hoop. Trim ½" hoop with vertical bandsaw if required, and shape to match slot with disc sander.

6. Welding – Lugs

AD-05

- a. Insert two 76423-05 lugs (medium basket) or 76423-06 lugs (long basket) into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 11" spacing jig with 3/8-24 bolts to lugs.
- b. TIG weld all around both sides of lugs. 2 places.
- c. Record lug and welding rod PO/WO on attached material list.

7. Welding – Handle Bushings – 84262-01

- a. Insert 84271-01 bushings into ½" hoop prepared in step 2. above.
- b. TIG weld bushing both sides, 2 bushings per hoop.
- c. Record bushing and welding rod PO/WO on attached material list.

8. Welding – Hoop Assembly

AD-05

- a. Insert 1" hoop from step 6 and ½" hoop from step 7 into hoop jig. Seat ½" hoop into slot in 1" hoop.
- b. Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
- c. TIG weld around ½" hoop in slot.
- d. Cap ½" – 1" tube joint with 76423-04 cap. TIG weld around cap.
- e. Record cap and welding rod PO/WO on attached material list.

9. Finishing and Inspection

AD-05

- a. Run 3/8-24 tap through welded lugs.
- b. Grind inside surfaces flush at lugs and slot in 1" tube.
- c. Inspect hoop for conformity to drawing.
- d. Tag complete and inspected hoop(s) and place into stock.

Work Order: 2014-03

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Hoops

1 of 1

Date Opened: 20 JAN 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1	<u>4</u>		76421-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>14009</u>
	<u>2</u>		76423-07	Hoop - attachment		
Step 1				1/2 Hoop Fabrication - 1/2" hoop		<u>PO# 13087</u> <u>14009</u>
	. 1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>13087</u>
Step 2				Machining	None	
Step 3				1/2 Hoop Fabrication - 1" hoop		
	. 1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	<u>PO# 13023</u>
Step 4				Machining	None	
Step 5				Joint Preparation	None	
				Welding		
Step 6	. 2		76423-06	Stud	1018 Mild Steel, 5/8" Dia.	<u>PO# 2013-24</u>
Step 7	. 2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	<u>WO# 2013-08</u>
Step 8	. 1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	<u>PO# 9010</u>
	. A/R		--	Welding Rod	ER70S-2	<u>PO# 11122</u>
Step 9				Finishing and Inspection	None	

CARGO BASKET HOOP FABRICATION - 76423

General

These instructions apply to cargo basket attachment hoop 76423-01 (medium AS350 basket) and 76423-07 (long AS350 basket). Refer to the following drawings, at the current revision, for dimensions and details:

76423, Revision 2 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly

Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order: 2014-03

Complete
(initial or SCA #)

Date Open: 20 Jan 2014

1. ½ Hoop Fabrication – ½" hoop

7006

- a. Cut ½" x 0.035 material to 22.0", square ends.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
 - i. Upper tube stop: ??"
 - ii. Lower bend stop: 12mm
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- j. Check for:
 - i. hoop height: 17 1/8" (Outside to outside)
 - ii. adjust upper stop for height if required

2. ½ Hoop Machining – ½" hoop – Handle Provisions (84262-01)

7006

- a. Start with ½" half hoop from step 1.
- b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
- c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
 - i. locate 0.23" from edge (within tolerance specified on drawing).
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Tag in process hoop(s) and place into stock.

Wo 2014-03
AS350 LONGComplete
(initial or SCA #)AD04

3. ½ Hoop Fabrication – 1" hoop ^{30.8"}
- Cut 1" x 0.065 material to 28.0", one end square, one end @ 16 degrees.
 - Record material PO on attached material list.
 - De-burr cut ends using a sanding disc on a die-grinder or disc sander.
 - Remove writing on tubes with acetone and scotch bright.
 - On the hoop bending fixture, set the following stops:
 - Upper tube stop: ??
 - Lower bend stop: ??
 - Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
 - Slide shim all the way forward on bender to secure tube in die
 - Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
 - Check tube bend for angle using hoop jig. Adjust stops if required.
 - Check for:
 - hoop height from jig
 - adjust upper stop for height if required
 - length to allow 60 degree cut.
 - Using hoop jig, mark for 60 degree cut on bottom end. Cut to length.
 - De-burr cut end using a sanding disc on a die-grinder or disc sander.
4. ½ Hoop Machining – 1" hoop ^{AD06}
- Start with 1" ½ hoop as stock.
 - Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.893" and set X 0. Shift Y -0.5". Set stop against end of tube.
 - Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
 - Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
 - Set tube in vise with 60 degree end on right.
 - Using ½" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
 - Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
 - Tag in process hoop(s) and place into stock.
5. Joint Preparation ^{AD06}
- Set 1" hoop in hoop jig. Insert ½" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto ½" hoop. Trim ½" hoop with vertical bandsaw if required, and shape to match slot with disc sander.
6. Welding – Lugs ^{AD-05}
- Insert two 76423-05 lugs (medium basket) or 76423-06 lugs (long basket) into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 11" spacing jig with 3/8-24 bolts to lugs.
 - TIG weld all around both sides of lugs. 2 places.
 - Record lug and welding rod PO/WO on attached material list.

WO 2014-03
AS350 LONG

Complete
(initial or SCA #)
AD-05

7. Welding – Handle Bushings – 84262-01

- a. Insert 84271-01 bushings into ½" hoop prepared in step 2. above.
- b. TIG weld bushing both sides, 2 bushings per hoop.
- c. Record bushing and welding rod PO/WO on attached material list.

8. Welding – Hoop Assembly

- a. Insert 1" hoop from step 6 and ½" hoop from step 7 into hoop jig. Seat ½" hoop into slot in 1" hoop.
- b. Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
- c. TIG weld around ½" hoop in slot.
- d. Cap ½" – 1" tube joint with 76423-04 cap. TIG weld around cap.
- e. Record cap and welding rod PO/WO on attached material list.

AD-05

9. Finishing and Inspection

- a. Run 3/8-24 tap through welded lugs.
- b. Grind inside surfaces flush at lugs and slot in 1" tube.
- c. Inspect hoop for conformity to drawing.
- d. Tag complete and inspected hoop(s) and place into stock.

AD-06

Work Order: 2014-03

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Hoops

1 of 1

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1	4		76421-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	PO# 13081
	2		76423-07	Hoop - attachment		
Step 1				1/2 Hoop Fabrication - 1/2" hoop		12123
	1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	
Step 2				Machining	None	
Step 3				1/2 Hoop Fabrication - 1" hoop		
	1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	13023
Step 4				Machining	None	
Step 5				Joint Preparation	None	
				Welding		
Step 6	2		76423-06	Stud	1018 Mild Steel, 5/8" Dia.	PO# 2013-24/13005
Step 7	2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	B# 7704 SS.
Step 8	1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	PO# 9010/12131 laser
	A/R		--	Welding Rod	ER70S-2	PO# 14005
Step 9				Finishing and Inspection	None	

CARGO BASKET BODY FABRICATION - COMMON

AS350 LONG (1)
WO# 2014-03
20-JAN-2014

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

Options 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

78411, Revision 2 – Long Basket

94011, Revision 0 – Extra Large (ski) Basket

Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right

90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

Options 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

MD600

82811, Revision 0 – Standard Basket

Options – Applicable to all models

70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 2014-03

AS350 LONG
78411

1

Date Open: 20 JAN 2014

AD-06

1. Rim Assembly – Basket Body

- Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig.
 - 1 or 2 lid prop bushing holes in short tube – refer to drawing
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.
- For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

2. Weld Rim Assembly.

- Record welding rod PO on attached material list.
- 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

AD-05

3. Inspection

- Rim for complete welds

AD-06

4. Frame assembly – body

- General
 - Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- Grind corner welds from step 2 on rim to allow hoops to sit flat.
- Pull required hoops from stock - standard, attachment, handle.
 - If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 - Ensure vent hole is located at centre of tube to vent spine tubes.
- Assemble hoops with attachment lug locating jig and hoop spacing jig.
 - Ensure correct order and orientation of hoops. Refer to drawing.
 - Attachment lugs are on inboard side.
 - Handle bracket bushings are on outboard side, second hoop from both ends.
May be on attachment hoops.
 - Run 3/8-24 tap into attachment lugs to ensure clear threads.
 - Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
 - Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
 - Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- Cut $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- Cut $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
 - Refer to applicable drawing for position, not required on some baskets.
- Option: Cut $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- 90611 (R44) only: Cut $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

AD-06

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
 - i. Extra large baskets
 - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim
 - ii. All other baskets
 - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly.

AD-05

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

6. Inspection

AD-06

- a. Frame assembly for complete welds.

7. Mesh assembly.

AD-06

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
 - i. For extra wide baskets only –
 - 1. Set $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
 - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
 - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
 - ii. Using markings on table, align sheet to indicated edge.
 - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
 - iv. Bend mesh by hand tightly over tube along length of tube.
 - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
 - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
 - i. General
 - 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
 - 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
 - 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
 - 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
 - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
 - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
 - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - v. Clamp mesh to spine in at least 1 place per section.
 - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
 - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
 - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/4" down at 60 degrees.
 - iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)
AD-05

8. Weld mesh to frame assembly per drawing.

- a. Ensure lug locating jig is in place prior to welding.
- b. General welding requirements for all baskets, MIG welding:
 - i. Every intersection at top edges.
 - ii. Every intersection at ends.
 - iii. First 5 intersections down on hoops, then every second intersection.
 - iv. Every intersection along spine.
 - v. Extra large baskets – every intersection along corner.
 - vi. Every intersection around ends
 - vii. Every intersection along struts (if applicable)
- c. Bend and trim cells bent in to fit mesh as required and weld in position.
- d. Grind high spots off body mesh welds on ends before welding end mesh.
- e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
- f. Record welding rod PO on attached material list.

9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
 - i. Record welding rod PO on attached material list.
 - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
 - i. Cut inboard rim on aft end. Grind flush with hoops.
 - ii. TIG weld caps on open tubes.
 - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
 - i. Record welding rod PO on attached material list.
 - ii. Record placard bracket WO on attached material list.

AD-05

10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

AD 06

11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
 - i. Hoops for height.
 - ii. Rim for width and length and alignment.
 - iii. Lid prop lugs in correct ends.
 - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

AD 01

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Asp

- e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.

Work Order: 2014-03Date Opened: 20 JAN 2014

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Body Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		78411-01	Basket Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (93.25")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>PO# 13087</u>
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>PO# 12123</u>
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>PO# 11122</u>
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 4		76421-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>PO# 13087</u>
	. 2		76423-01	Attachment hoop (aft)		
	. 5		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>PO# 12123</u>
Step 4.g.		70406	70406-01	Option: Front End Cutout		
			70406-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>PO# 12123</u>
			70406-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>PO# 12123</u>
Step 5				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>PO# 11122</u>
Step 6				<i>Inspection - Frame Assembly</i>	None	
Step 7				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 48" x 92.25")	3/4-16F Expanded Mild Steel sheet	<u>PO# 13078</u> new batch
	. 2		--	Mesh (End - 22" x 17")	3/4-16F Expanded Mild Steel sheet	<u>PO# 13078</u> new batch
Step 8				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	<u>PO# 14005</u>

Work Order: _____

Date Opened: _____

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Body Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 9				<i>Weld Basket Components</i>		
Step 9.a.	2		49215-01	Spacer (Lid prop)	304 Stainless Steel, ½" Dia.	WO# 2013-55
	A/R		--	Welding Rod	ER308L TIG Rod	ER347
Step 9.b.	2		--	Cap	1018 Mild Steel, 0.032" Sheet	PO# 9010
	A/R		--	Welding Rod	ER70S-2 TIG Rod	
Step 10				<i>Clean Up</i>	<i>None</i>	
Step 11				<i>Inspection - Final Assembly</i>	<i>None</i>	
Step 12				<i>Powder Coating</i>		

CARGO BASKET LID FABRICATION - COMMON

AS350 LONG
2014-03

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right)

78412, Revision 2 – Long Basket

94012, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

Bell 429 – right or left

95912, Revision 0 – Standard Basket

Bell Medium – left or right

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

MD600

82812, Revision 0 – Standard Basket

Options

70405, Revision 3 – Walkway

70402, Revision 1 – Lid Door

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

Work Order: 2014-03

AS350 LONG 1

Date Open: 20 JAN 2014

78412

AD-05

1. Rim Assembly – Basket Lid

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.

2. Weld Rim Assembly

- a. Record welding rod PO on attached material list.

AD-05

3. Inspection

- a. Rim for complete welds

AD-06

4. Frame assembly – Lid

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- b. Insert rim from step 2 into jig.
- c. Cut and fit $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- d. Record material PO on attached material list.
- e. Remove writing on tubes with acetone and scotch bright.
- f. Drill vent holes into rim to vent cross members into rim.
- g. Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

AD-06

5. Frame assembly – Lid with optional walkway modification

- a. Fit cross members to rim in accordance with step 4.
- b. Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- c. Cut $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- d. Drill vent holes into cross members at walkway stringers.
- e. Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

AD-06

6. Weld frame assembly.

- a. Record welding rod PO on attached material list.
- b. Jigs must remain in place for as long as practical during welding.

AD-05

7. Inspection

- a. Frame assembly for complete welds.

AD-06

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

AD06

8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for lid.
- c. Remove surface rust with scotch-brite.
- d. Ensure lid is prepared for mesh on the correct side.

9. Weld mesh to frame assembly per drawing.

AD-05

- a. General welding requirements for all lids:
 - i. Every intersection on all edges.
 - ii. First 5 intersections along cross members, then every second intersection.
- b. MIG weld both short sides.
- c. Clamp lid over spacer at centre of lid to pre-tension mesh.
 - i. $\frac{3}{4}$ " for lids under 76"
 - ii. 1" (check) for lids over 76"
- d. Weld remainder of mesh as indicated in a.
- e. Record welding rod PO on attached material list.

10. Weld lid components.

AD-05

- a. Handle brackets, locate in accordance with drawing.
 - i. Standard location: $\frac{1}{4}$ " outside of last cross member on both ends.
 - ii. Record handle bracket WO and welding rod PO on attached material list.
- b. Lid prop bushing(s).
 - i. one or two in accordance with drawing.
 - ii. Record lip prop bushing WO and welding rod PO on attached material list.
- c. Placard bracket. – not installed on 95912 (Bell 429)
 - i. Locate on cross member to set bracket in centre bay of lid.
 - ii. Record placard bracket WO and welding rod PO on attached material list.

11. Clean up

AD06

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- c. Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- d. Drill #9 through lid prop bushing(s). De-burr hole(s).
- e. Drill for lid bumpers using $\frac{1}{4}$ " (#3) centre drill.
 - i. 3 places for lids under 76"
 - ii. 4 places for lids over 76"
- f. Remove surface rust with scotch-brite pad.

12. Final Inspection

To be completed by a different person than the previous steps.

AD

- a. Basket lid assembly for complete welds, and required minimum mesh weld locations.
- b. Material lists complete.
- c. Overall condition and conformity to drawing(s).

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

4001

13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag lid assembly and place into stock in preparation for assembly.

Work Order: 2014-03Material Tracking Sheet
Eurocopter AS350 / AS355
Long Lid Fabrication

1 of 2

Date Opened: 20 JAN 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		78412-01	Lid Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (93.25")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>PO# 13087</u>
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>PO# 12123</u>
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>PO# 11122</u>
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 4		--	3/4" Tube - Cross Member (21")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>PO# 12123</u>
Step 5		70405		<i>Option: Frame Assembly - with walkway</i>		
	. 8		--	1/2" Tube - walkway	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>PO# 12123</u>
Step 6				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>PO 11122</u>
Step 7				<i>Inspection - Frame Assembly</i>	None	
Step 8				<i>Mesh Assembly</i>		
	. 1		--	Mesh (lid - 92.5" x 22")	3/4-16F Expanded Mild Steel sheet	<u>PO# 13078</u>
Step 9				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	<u>PO 14005</u>

Work Order: _____

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Lid Fabrication

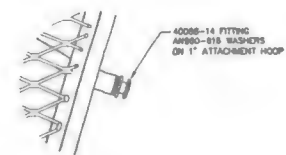
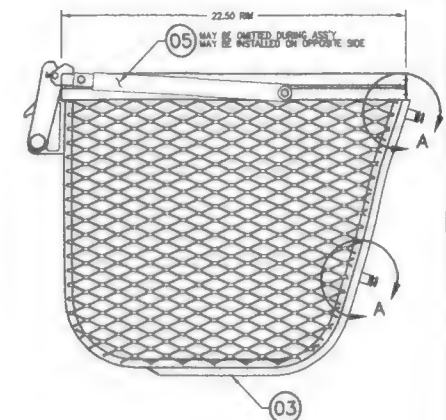
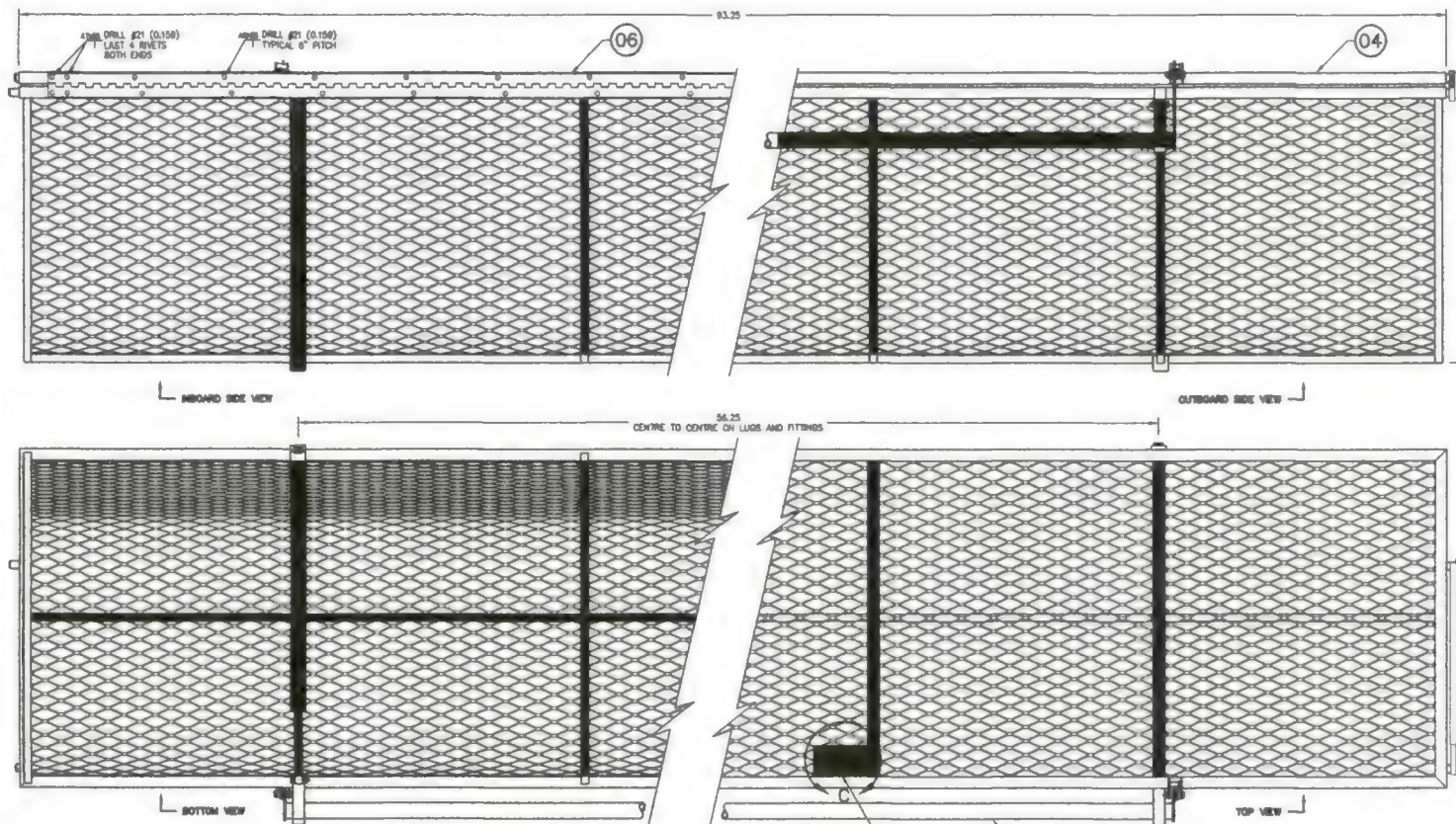
2 of 2

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 10				<i>Weld Lid Components</i>		
	. 1	84262	84262-01	Upper Handle Bracket Assembly		rob
	. . 4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	PO# 10037
	. . 2		36275-02	Support	304 Stainless, 5/16" Rod	13004
	. A/R		--	Welding Rod	ER308L TIG Rod	ER347
	. 2		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	PO# 2013-55
	. A/R		--	Welding Rod	ER308L TIG Rod	ER347
	. 1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	PO# 2013-56
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	PO# 14005
Step 11				<i>Clean Up</i>		
Step 12				<i>Inspection - Final Assembly</i>		
Step 13				<i>Powder Coating</i>		

[illegible]

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	CHANGED HANDLE CONFIGURATION, REMOVED ALTERNATE BASKET	REC	27 JAN 10



DETAIL A
SCALE 1 : 2
TYPICAL FRONT AND REAR

NOTE:
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED BY PREVIOUS STEPS.

01 CARGO BASKET ASSEMBLY

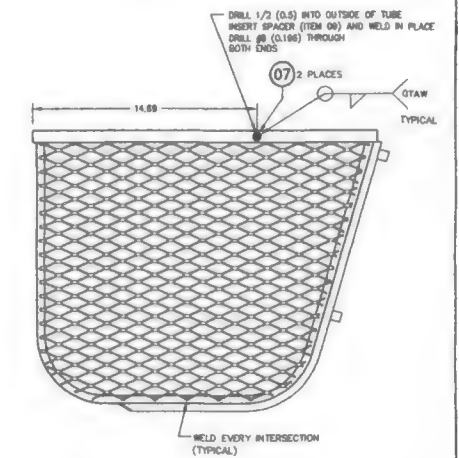
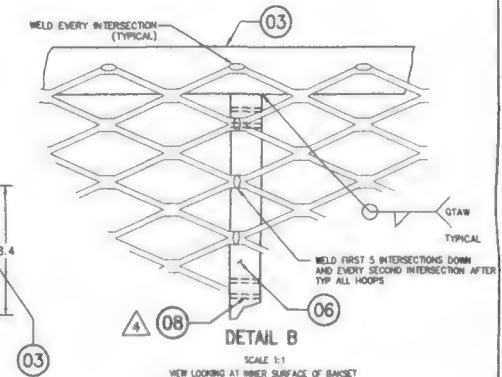
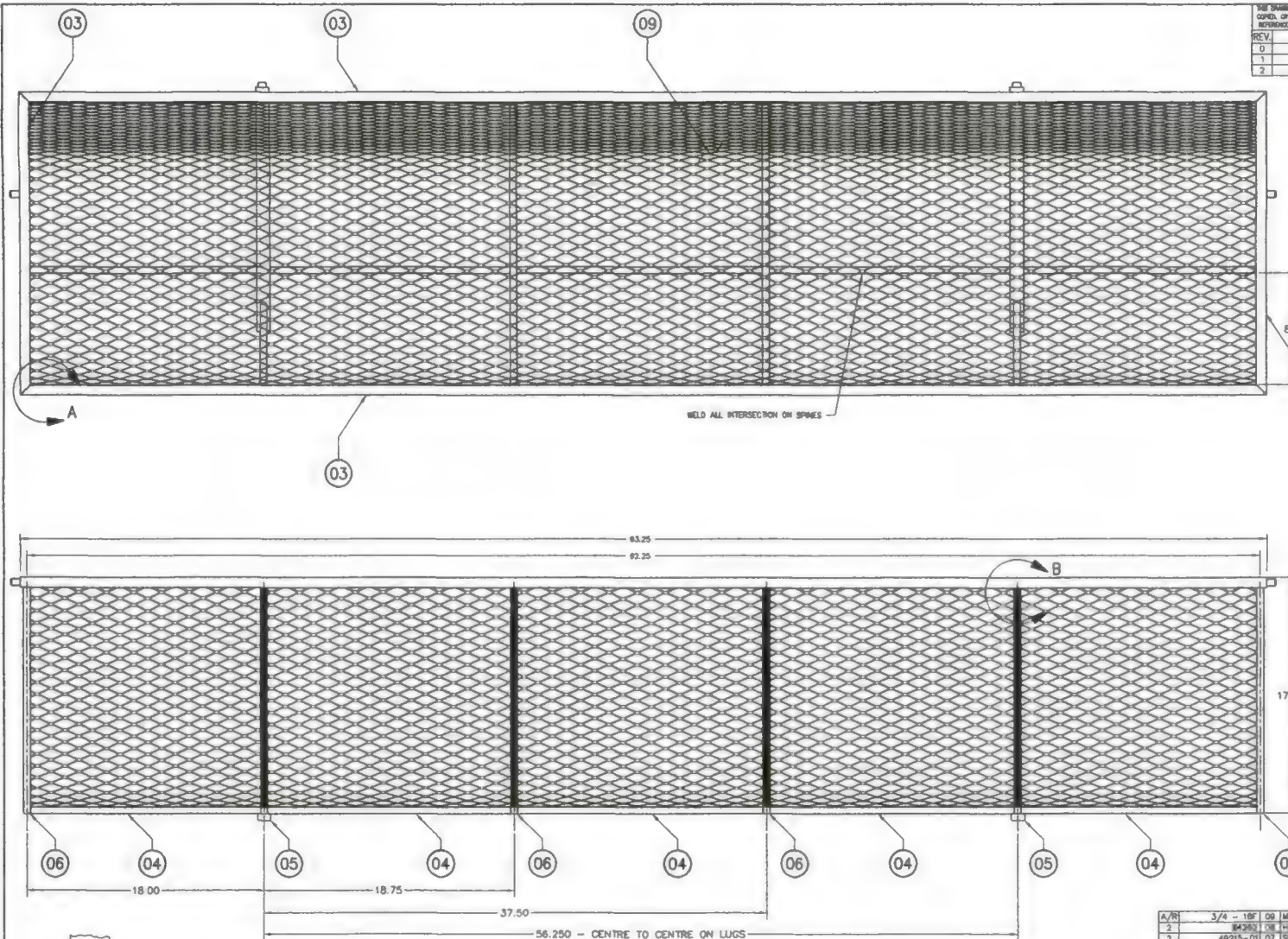
A/R	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
4	4008B-14		FITTING			
8	CR3523-5-02		CHERRY RIVET			
A/R	CR3213-5-02		CHERRY RIVET			
4	CR3213-4-02		CHERRY RIVET			
3	40205-14-08		BUMPER			
1	78427-01		PLACARD		ARGUS INDUSTRIES	
1	84255-01		HANDLE BAR INSTALLATION			
A/R	MS20001P4		PIANO HINGE			B2 LONG
1	36280-01		BRACE ASSEMBLY			
1	78412-01		LID ASSEMBLY			
1	78411-01		BASKET BODY ASSEMBLY			
01	78410-01		CARGO BASKET ASSEMBLY			

LIST OF MATERIALS

BASIC CODE REF. HAS 523		DASH NO. FOR DIAMETER H=H/D HEAD NEAR SIDE F=H/D HEAD FAR SIDE	APPROVALS		DATE
C=COUNTERSINK D=DIMPLE DIST=OF SHEETS TO BE CIRCLED		DASH NO. FOR LENGTH	DRAWN: R. RATHWELL CHECKED: E. BURGOIN		19 FEB 08
BASIC CODES: BJ=MS20470AD BB=MS20426AD AR=CR3213 ATM=CR3523		<div><div>+</div><div>+</div><div>+</div></div> <div><div>+</div><div>+</div><div>+</div></div> <div><div>+</div><div>+</div><div>+</div></div>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		
		<div><div>+</div><div>+</div><div>+</div></div> <div><div>+</div><div>+</div><div>+</div></div> <div><div>+</div><div>+</div><div>+</div></div>	DECIMALS ANGLES X/100 ±0.010 X/10 ±0.01 X/1 ±0.1		
		<div><div>+</div><div>+</div><div>+</div></div> <div><div>+</div><div>+</div><div>+</div></div> <div><div>+</div><div>+</div><div>+</div></div>	SCALE 1 : 4 SHEET 1 OF 1		
		<div><div>+</div><div>+</div><div>+</div></div> <div><div>+</div><div>+</div><div>+</div></div> <div><div>+</div><div>+</div><div>+</div></div>	DASH NO. DASH NO. REV 01 78410 1		

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	25 JAN 08
1	CHANGED ATTACH HOOP FROM 78423-01 TO 78423-07	RR	05 MAR 08
2	CHANGED HANDLE BRACKET, REMOVED ALTERNATE BASKET	SJC	28 JAN 10



01 BASKET BODY ASSEMBLY

- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
 2. PRIOR TO WELDING, DRILL 3/32 VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
 3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS D685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
 4. INSTALL ITEM 8 (HANDLE BRACKET ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84382 TYP 2 PLACES.
 5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

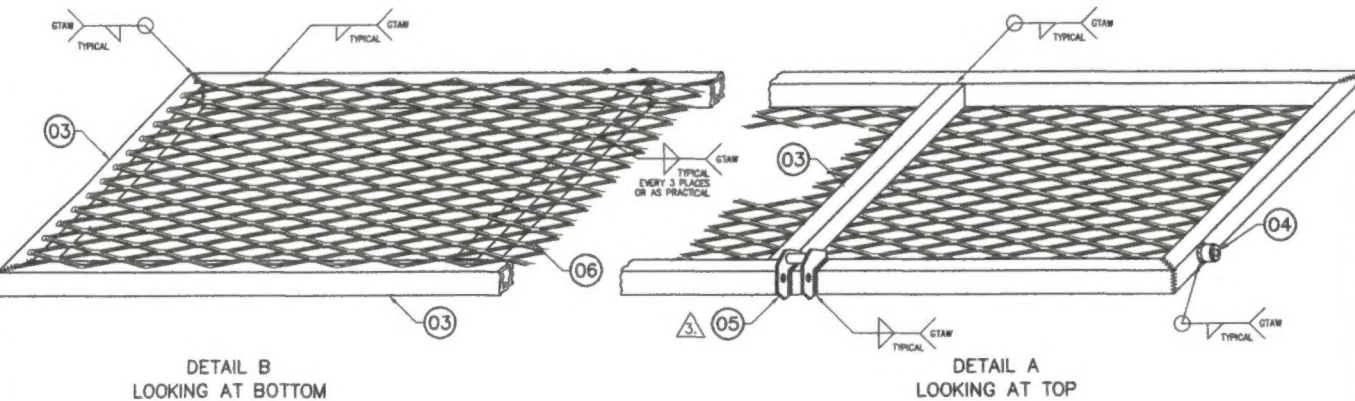
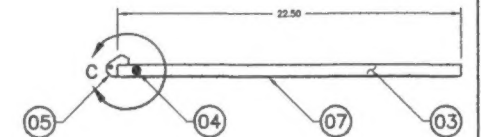
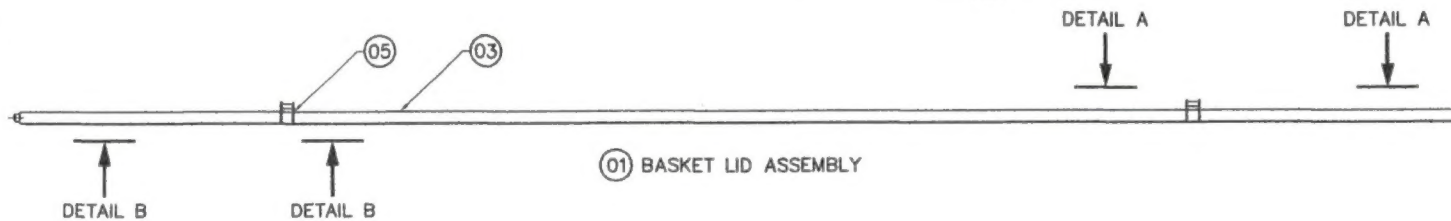
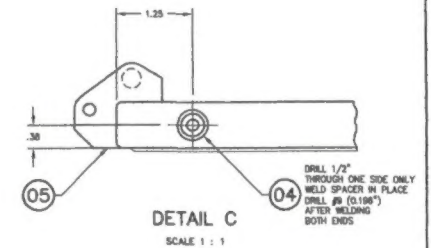
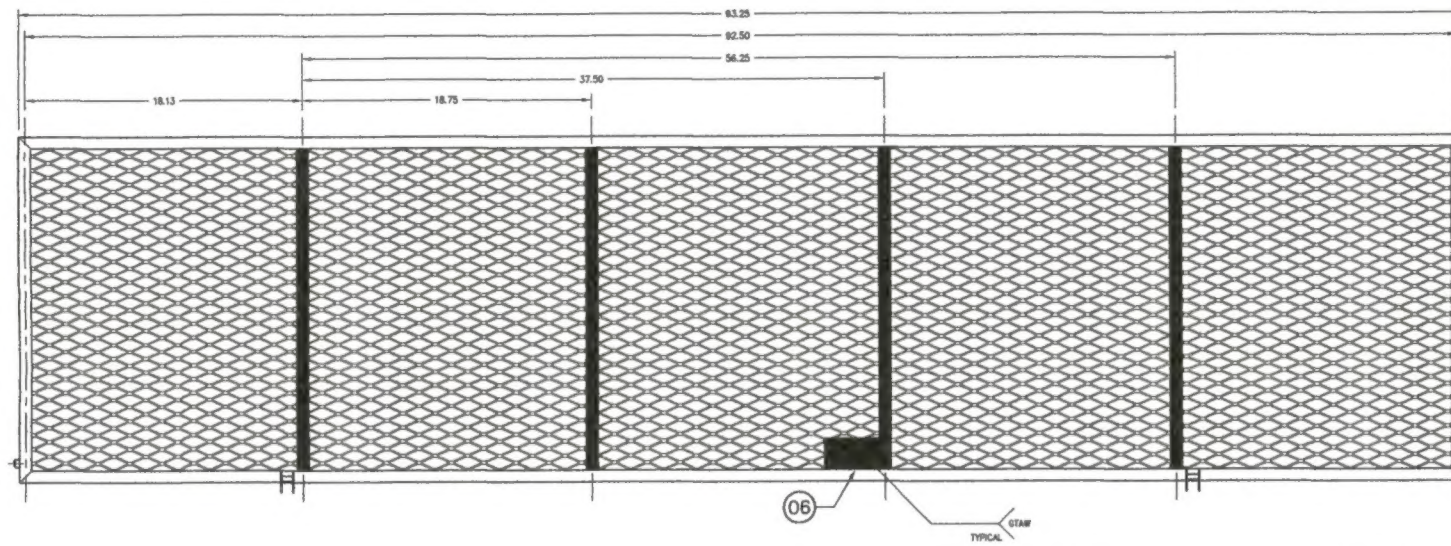
A/R	3/4 - 18#	08 MESH	STEEL	STEEL	
2	84282-08	HANDLE BRACKET ASSEMBLY			
2	48215-01	07 SPACER			
4	78421-01	08 HOOP			
2	78423-07	05 ATTACHMENT HOOP			
A/R		04 SQUARE TUBE	4130 STEEL COND. N	ML-T-6736	1/2 X 0.032 SQR TUBE
A/R		01 SQUARE TUBE	4130 STEEL COND. N	ML-T-6736	3/4 X 0.032 SQR TUBE
		02			
		78411-01	01 BASKET BODY ASSEMBLY		
01	PART NO.	ITEM	DESCRIPTION	MATERIAL/NOTE	MATERIAL SPEC STOCK SIZE
QTY	LIST OF MATERIALS				
APPROVALS			DATE		
DRAWN: R. RATHWELL			25 JAN 08		
CHECKED: C. BURGOON			<div>AERO DESIGN LTD.</div> <div>CONSULTING ENGINEERS, TRANSPORT CANADA APPROVED, DAR 280M</div> <div>3015 - 50TH AVENUE N.E., CALGARY, ALBERTA, CANADA. T2C 6R7</div> <div>tel: (403) 860-8867 fax: (403) 860-8880 www.aerodesign.ca</div>		
UNLESS OTHERWISE SPECIFIED					
DIMENSIONS ARE IN INCHES.					
TOLERANCES ARE:					
DECIMALS ANGLES					
X.XXX ±0.010 ±1/2°					
X.XX ±0.03					
X.X ±0.1					
SCALE 1 : 4			SMB SIZE SMC NO. REV.		
SHEET 1 OF 1			A1 78411 2		

DETAIL A
SCALE 1:1

AERO DESIGN LTD.
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 2808
8019 - 58TH AVENUE N.E., CALGARY, ALBERTA, CANADA T2E 6B7
tel: (403) 880-8887 fax: (403) 880-8888 www.aerodesign.ca

**EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
BASKET BODY ASSEMBLY**

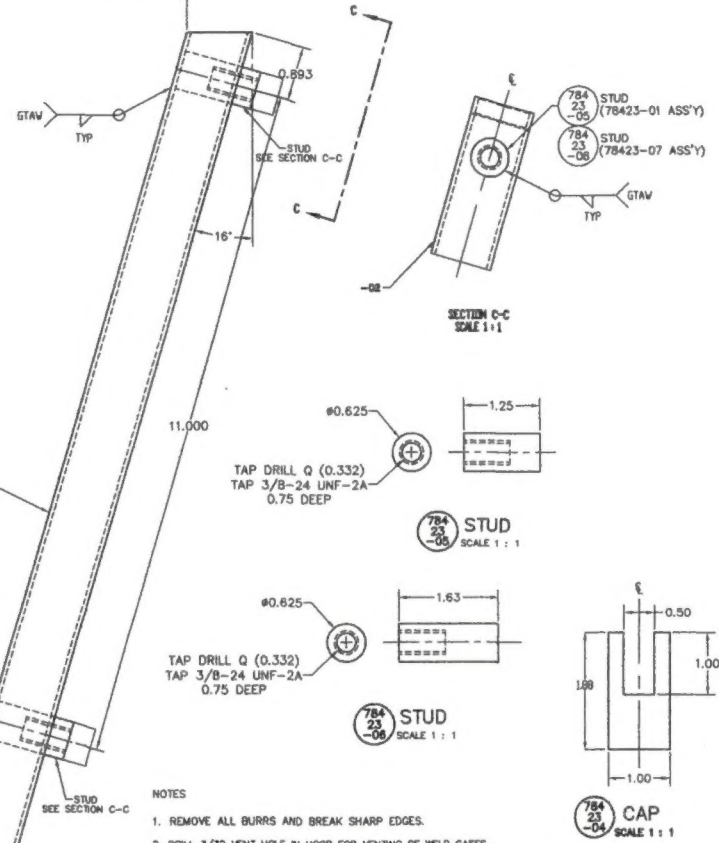
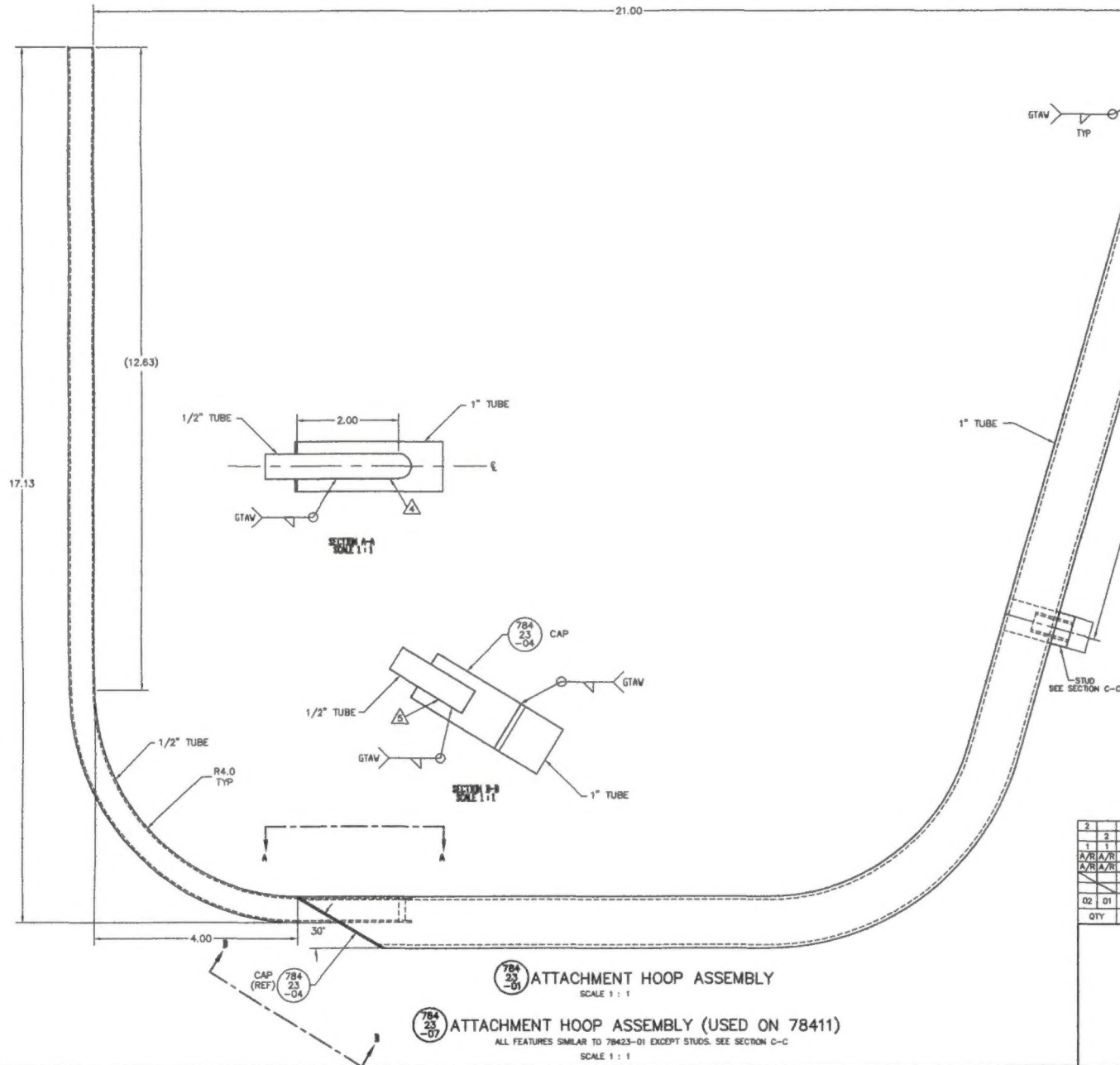
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	CHANGED HANDLE BRACKETS, REMOVE ALTERNATE LID	BUC	28 JAN 10



- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
 2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2088C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
 3. INSTALL ITEM 5 (HANDLE BRACKET ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 36262 TYP 2 PLACES.
 4. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
 5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

A/R	3/4-16F 07 MESH				
1	36204-10 06 PLACARD BRACKET				
1	84262-01 05 UPPER HANDLE BRACKET ASSY				
2	46216-01 04 SPACER				
A/R	03 SQUARE TUBE	4130 STEEL COND N.	MIL-T-8738	3/4 X 0.039 SQF TUBE	
	02				
78412-01	01 BASKET LID ASSEMBLY				
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY					
LIST OF MATERIALS					
APPROVALS		DATE	AERO DESIGN LTD.		
DRAWN: R. RATHWELL		19 FEB 08	CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 2800M		
CHECKED: E. BURROON			2015 - 50TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6B7		
			Tel: (403) 260-8877 Fax: (403) 260-8850 www.aerodesign.ca		
UNLESS OTHERWISE SPECIFIED			EUROCOPTER AS350 & AS355 SERIES		
DIMENSIONS ARE IN INCHES			QUICK RELEASE CARGO BASKET		
TOLERANCES ON:			BASKET LID ASSEMBLY		
DECIMALS		ANGLES	SCALE 1 : 4	QMC SIZE	QMC NO.
X.XXX ±0.010		±1/2"			
X.XX ±0.03					
X.X ±0.1					
			SHEET 1 OF 1	A1	78412
					1

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	24 JAN 08
1	ADDED 78423-07 ASSY AND 78423-06 PART	RR	05 MAR 09
1	CHANGED LENGTH OF STUD (ITEM 05)	BUC	16 JUNE 10



NOTES

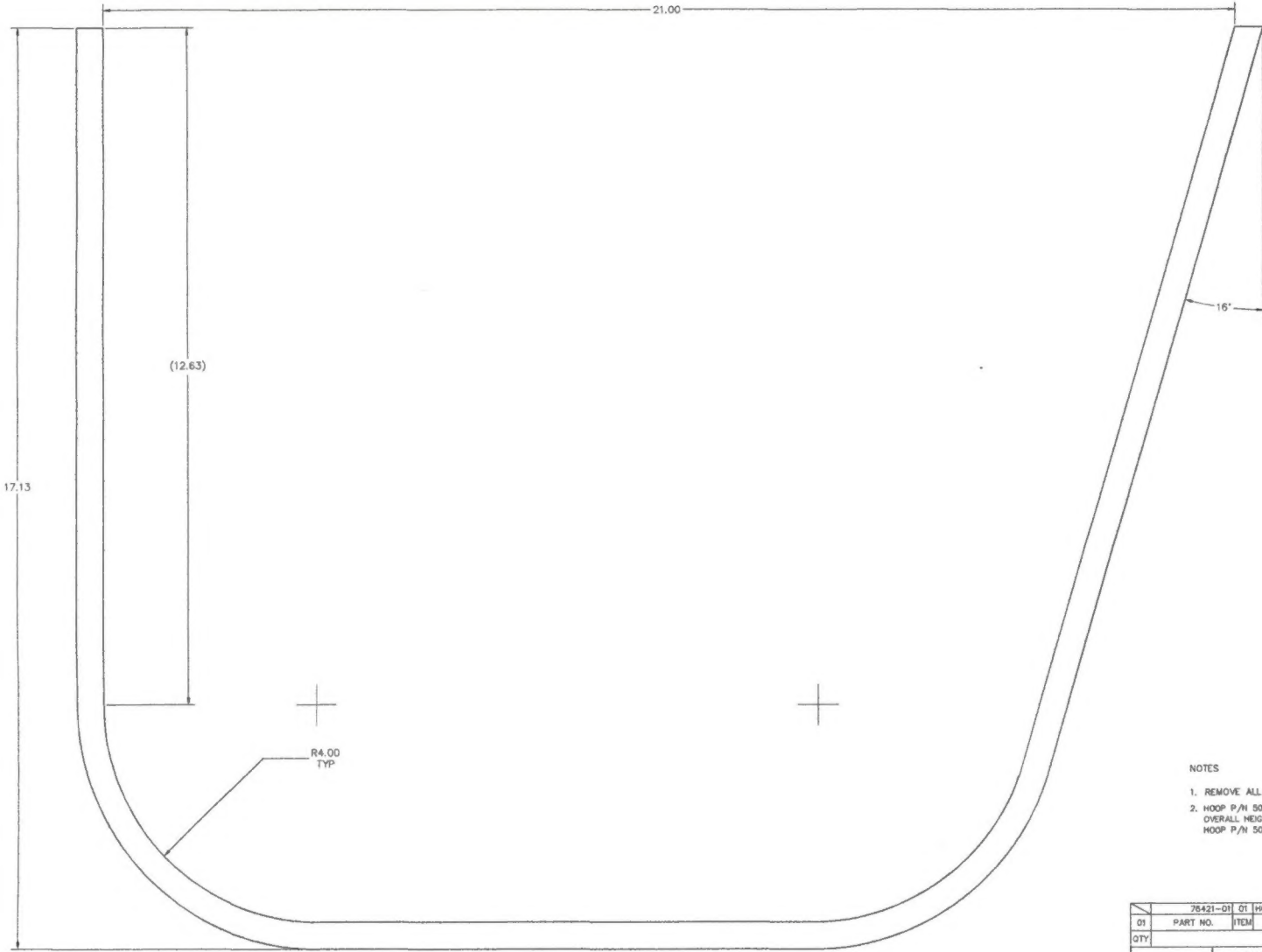
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
 2. DRILL 3/32 VENT HOLE IN HOOP FOR VENTING OF WELD GASES.
 3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2885C. WELDING ROD SHALL CONFORM TO AMS E70S-2 OR EQUIVALENT.
- ▲ MILL SLOT INTO ITEM 1" TUBE AS SHOWN. CONTOR END OF 1/2" TUBE TO MINIMIZE GAP BETWEEN 1" TUBE AND ITEM 1/2" TUBE.
- ▲ ADJUST SLOT OF CAP (78423-04) TO FIT AS REQUIRED.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2	78423-08	08	STUD	MILD STEEL	ANSI 1010/1020	#0.63 ROD
1	78423-05	05	STUD	MILD STEEL	ANSI 1010/1020	#0.63 ROD
1	78423-04	04	CAP	MILD STEEL SHEET	0.025 SHEET	
A/R/A/R	03	TUBE 1/2IN	4130 STEEL COND. N	MIL-T-6736	0.5 X 0.035 SQR TUBE	
A/R/A/R	02	TUBE 1IN	4130 STEEL COND. N	MIL-T-6736	1 X 0.065 SQR TUBE	
78423-07	07	ATTACHMENT HOOP ASSEMBLY	(USED ON 78411)			
78423-01	01	ATTACHMENT HOOP ASSEMBLY				

LIST OF MATERIALS			
QTY	PART NO.	ITEM	DESCRIPTION
2	78423-08	08	STUD
1	78423-05	05	STUD
1	78423-04	04	CAP
A/R/A/R	03	TUBE 1/2IN	4130 STEEL COND. N
A/R/A/R	02	TUBE 1IN	4130 STEEL COND. N
78423-07	07	ATTACHMENT HOOP ASSEMBLY	(USED ON 78411)
78423-01	01	ATTACHMENT HOOP ASSEMBLY	

APPROVALS		DATE	AERO DESIGN LTD.	
DRAWN:	R. RATHWELL	24 JAN 08	CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 890M	
CHECKED:	E. BURROON		2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6G7	
UNLESS OTHERWISE SPECIFIED			AS350 & AS355 SERIES	
DIMENSIONS ARE IN INCHES.			QUICK RELEASE CARGO BASKET	
TOLERANCES DIM.			ATTACHMENT HOOP ASSEMBLY	
DECIMALS			SCALE 1 : 1	
X.XXX ±0.010			DWG. SIZE	
X.XX ±0.03			DWG. NO.	
X.X ±0.1			REV.	
			SHEET 1 OF 1	
			A1 76423 2	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	24 JAN 08



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. HOOP P/N 50510-01 IS USED AS A DIRECT REPLACEMENT FOR HOOP P/N 78421-01.
OVERALL HEIGHT IS REDUCED BY 1.38 IN. THERE ARE NO OTHER CHANGES.
HOOP P/N 50510-01 IS USED ON BASKET S/N 78401-01, 78401-02, 78401-01, 77601-01, 77602-01 ONLY.

76421-01	01	HG	4130 STEEL CONG. N	MIL-T-6736	0.5 X 0.035 50R TUBE
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC
QTY	STOCK SIZE				
			LIST OF MATERIALS		
APPROVALS DRAWN: R. RATHWELL CHECKED: E. BURGGIN DATE: 24 JAN 08			AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 30TH AVENUE N.E., CALGARY, ALBERTA, CANADA. T2S 0R7 Tel: (403) 850-9097 fax: (403) 850-6350 www.aerodesign.ca		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1			EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET HOOP		
SCALE 1 : 1 SHEET 1 OF 1			DIM. SIZE DIM. NO. REV. A1 76421 0		

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	INCREASE LOAD TO 250 LBS / 113 KG	BJC	JAN 27/10

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
"QUICK RELEASE BASKET" - 0.125 HIGH
"EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH
"S/N 78401-XX" - 0.080 HIGH
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
"250 LBS/113 KG" - 0.200 HIGH
"AERO DESIGN LTD." - 0.125 HIGH
"CALGARY, ALBERTA, CANADA" - 0.080 HIGH
"403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)
4 PLACES



01 PLACARD

78427-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

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	DRAWN: R. RATHWELL		18 FEB 08		EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET PLACARD			
	CHECKED: E. BURGAIN							
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1							
	SCALE 1 : 1		DWG. SIZE		DWG. NO.		REV.	
SHEET 1 OF 1		A1		78427		1		